

Date: Monday, 25/05/2009 12:48:49 PM  
 User: Julie Dawson

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP  
 Job Number : 48195  
 Estimate Number : 11119  
 P.O. Number :  
 This Issue : 25/05/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D30411  
 First Issue : // Type : MACHINED PARTS Drawing Number : D3041 REV.C  
 Previous Run : 46614 Project Number : N/A  
 Material :  
 Due Date : 12/06/2009 Qty: -40 Um: Each  
 Written By :  
 Checked & Approved By : H. H. H. 25/05/09  
 Comment : Est:A 01.07.11 New Issue SM  
 est B 07.04.09 rev.c dwg EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0875 f(s)/Unit Total : 3.4986 f(s)

Lug Extrusion

(D2423)

Batch: 043722

09/06/10

40

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

09/06/10

40

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA153

P15

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 09/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3041-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: JA Date: 09.07.07  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: JA Date: 09.07.15

NCR: <u>48195</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.06.16	3	Tabs on inner bore have excessive de-burring (0.078"). Wrong program used Qty (8) affected	CP 09.05.16 pu OS/042	Acceptable: SCRAP. Qty (8) DTP Radius on bolt relief 0.032 instead of 0.063". PARTS W/ R0.063 ARE OK Repace B#43722 *	09/06/16	S 02/06/24	CP 09.06.16 pu OS/042	S 02/06/24

NOTE: Date & initial all entries

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Drawing Name: CLAMP

Job Number: 48195

Part Number: D30411

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

UMD 09/06/22 (240)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

50766/22 (240) center

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

~~Powder Coat White Gloss~~ (Ref: 4.3.5.1) as per QSI 005 4.3

~~Mask inside of 0.8120" diameter hole~~

START TIME: 12:40pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:10pm

91 09-06-22 (240)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

09/6/22 (40)

10.0	D2611	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bearing

Pick:

Qty	Part Number	Description	Batch
1	D2611	Bearing	46841

09/6/22

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041 using DT9472

2- Stake bearing into place as per Dwg D3041 using DT9456

3- Touch up stake mark with white Imron paint using fine point paint brush.

PTD 09/06/24 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3041-1 PAR #: N/A Fault Category: Sm fab NCR: (Yes) No DQA: / Date: 09.06.25  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 09.07.15

NCR: <u>48195</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/06/24</u>	<u>11</u>	<u>1 lug was scrap bearing moved when was press + damaged lug RC: process</u>	<u>/</u> <u>BS11412</u>	<u>Scrap + destroy No replace</u>	<u>SB</u> <u>09/06/24</u>	<u>/</u> <u>09/06/24</u>	<u>/</u> <u>BS11412</u>	<u>/</u> <u>09.06.24</u>

NOTE: Date & initial all entries

Date: Monday, 25/05/2009 12:48:49 PM  
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Drawing Name: CLAMP

Job Number: 48195

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50266624

cert

(E24)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 463

9/6/24

SD

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 J

Job Completion



12 09.06.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 4825
<b>Description:</b> Clamp		<b>Part Number:</b> D3041-1
<b>Inspection Dwg:</b> D3041	<b>Rev:</b> C	<b>Page 1 of 1</b>

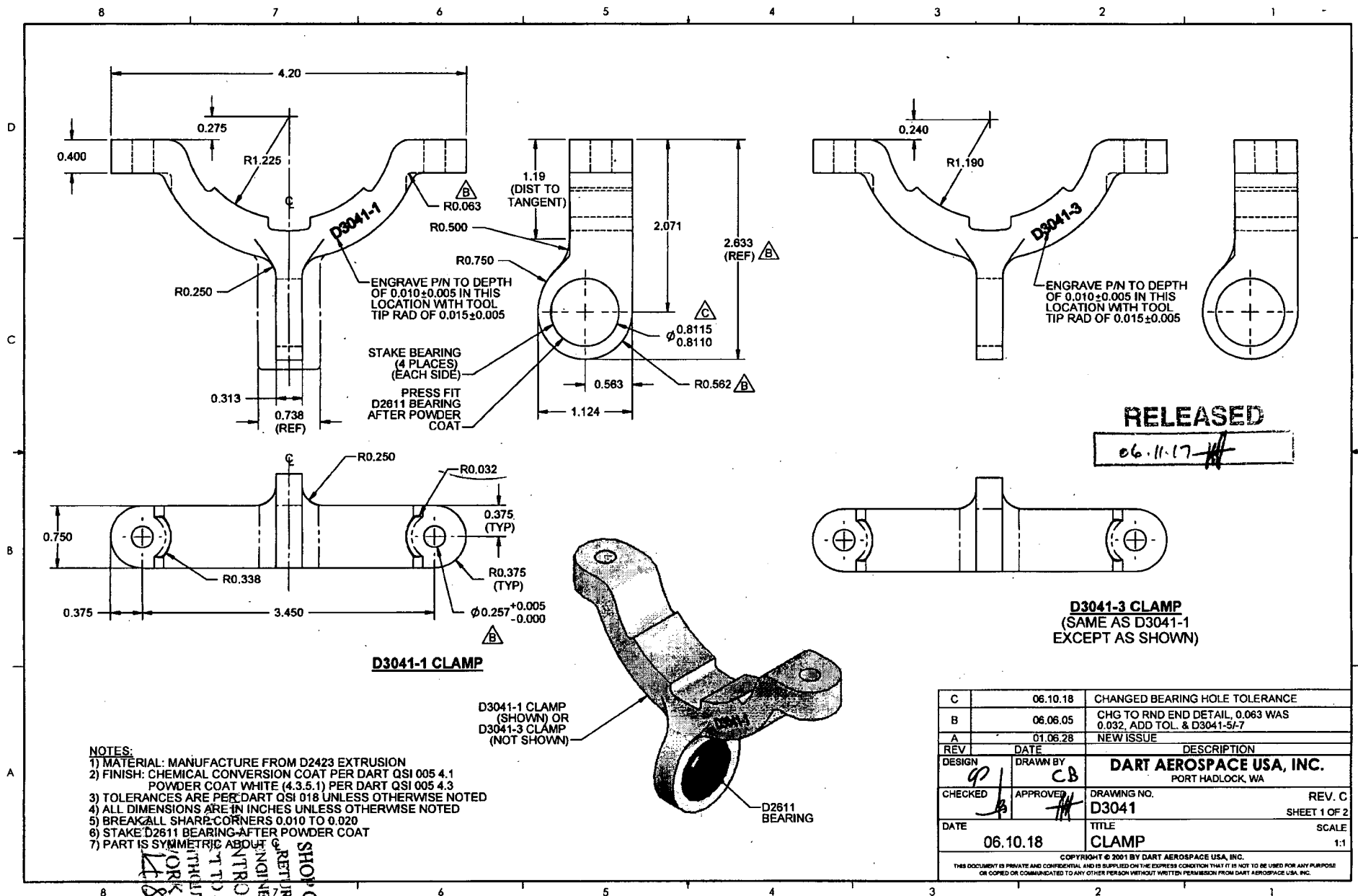
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	+/-0.030	4.203	✓			
0.275	+/-0.010	0.275	✓			
R1.225	+/-0.010	1.225	✓			
0.400	+/-0.010	0.400	✓			
R0.250	+/-0.010	0.250	✓			
0.313	+/-0.010	0.314	✓			
R0.063	+/-0.010	0.063	✓			
1.19	+/-0.030	1.19	✓			
1.124	+/-0.010	1.129	✓			
0.563	+/-0.010	0.564	✓			
R0.562	+/-0.010	0.562	✓			
Ø0.8115 - 0.8110	N/A	0.811	✓			
2.071	+/-0.010	2.073	✓			
0.750	+/-0.010	0.750	✓			
0.375	+/-0.010	0.373	✓			
R0.338	+/-0.010	0.338	✓			
3.450	+/-0.010	3.448	✓			
Ø0.257	+0.005-0.000	0.258	✓			
R0.375	+/-0.010	0.376	✓			
0.375	+/-0.010	0.375	✓			
<del>R0.032</del>	<del>+/-0.010</del>	<del></del>	<del></del>	<del></del>	<del></del>	<del></del>
R0.250	+/-0.010	0.250	✓			

<b>Measured by:</b> DJT	<b>Audited by:</b> J.L.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/06/16	<b>Date:</b> 09/06/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	



C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5/7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3041
DATE	06.10.18	TITLE CLAMP
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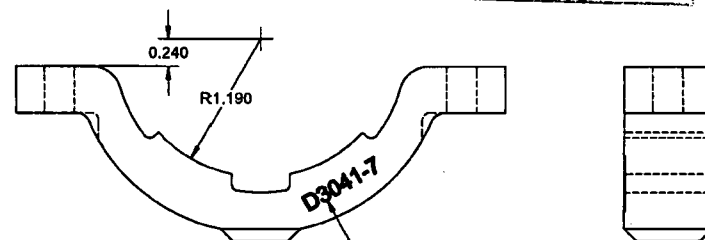
SHOP COPY  
 RETURN TO  
 ENGINEERING  
 CONTROLLED COPY  
 1 TO AMENDMENT  
 NOTICE  
 WORK ORDER  
 148115



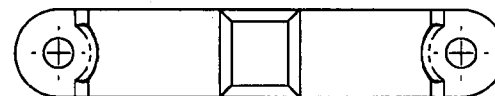
06.11.17 ~~th~~




—ENGRAVE P/N TO DEPTH  
OF  $0.010 \pm 0.005$  IN THIS  
LOCATION WITH TOOL  
TIP RAD OF  $0.015 \pm 0.005$

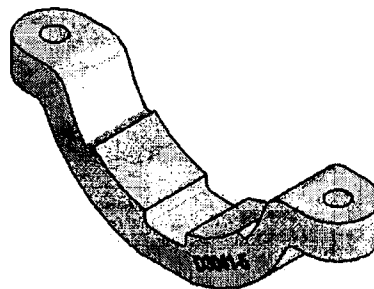


—ENGRAVE P/N TO DEPTH  
OF  $0.010 \pm 0.005$  IN THIS  
LOCATION WITH TOOL  
TIP RAD OF  $0.015 \pm 0.005$



**D3041-7 CLAMP**  
(SAME AS D3041-5  
EXCEPT AS SHOWN) 

**D3041-5 CLAMP** 



1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
5) BREAK-ALL SHARP CORNERS 0.010 TO 0.020  
6) PART IS SYMMETRIC ABOUT C

NO. 1845

DESIGN	DRAWN BY	<b>DART AEROSPACE USA, INC.</b>	
Q1	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
JB	#	D3041	SHEET 2 OF 2
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